

Work Order ID 55551 -1

January 20, 2010 11:04:34 AM

Page 1

Item ID: D2492

Revision ID:

Item Name: Patient Stop

Start Date: 1/20/10 Start Qty: 10.00

Required Date: 1/29/10 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2492

Rev F

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D2492
Deburr if necessary

Dwg Rev:

F

Prog Rev:

f

2-

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAI3

Memo

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

1B 10-1-21

1B 10-1-21

⇒ 8/10/1/22

214

5

MDA

Work Order ID 55551

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QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr Form using Jig DT2492B

0.00

0.00

SAD 10-05-28

①

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Sub 5/31

x1

Test Fit on 25 emergency stocker

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

1 DR 10-5-31.

PTO

large fab.

-135

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2492 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>55551-1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10.5.25</u>	<u>135</u>	<u>Fill in bottom holes w/ weld</u>		<u>No consistency between holes of boiler kit + patient stop see attached URM</u>		<u>N/A</u>	<u>P</u>	<u>10.06.09</u>

NOTE: Date & initial all entries

Under Review Notification

Raised By: C Provencal

Date: 10.05.20

Product #: D350-616

Product Name: Litter Kit

Drawing/Kit Number	Drawing/Kit Description	Quantity on Hand (Stock)	Quantity on Order (Production)	Quantity Allocated (Customer Order)	HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise customers	Stop Production	Re-Work Stock	IPP Under Review	Blue File Under Review	ECN #	Instructions
D2492	Patient Stop				N	Y	N	Y	Y	Y	Y	10-577	Quarantine stock, rework per instructions
D2493	Patient Stop Assembly				N	Y	N	Y	Y	Y	Y	10-577	below, OK to ship after rework.
D350-616-011	Full Litter Kit				N	Y	N	N	Y	Y	Y	10-577	Get ENG sign off to produce more, with lower hole removed.

Description of issue:

- Location of holes in litter kit for installation of patient stop has no consistency between batches.
- Lower hole from D2492 Patient Stop will be removed. As part of assembling litter kit, patient stop will be drilled to match litter. For replacement parts, customer will transfer drill patient stop to fit litter.
- Rework existing stock of D2492/D2493 patient stops to remove lower hole. Any patient stops already in kits that fit their litter are OK as-is.
- Ensure for any D315-616-011 in stock that the patient stop fits the litter.

Distribution:

General Manager

Production Manager

Director Quality Assurance

Design Manager

Chief Engineer

Production Engineering Coordinators

Quality Assurance Coordinator

Quality Control Coordinator

Order Processing

Customer Technical Support

Engineering Project Managers

Engineering Clerk

Marketing

Work Order ID 55551

January 20, 2010 11:04:35 AM



Item ID: D2492

Accept



Setup Start



Revision ID:

Stop



Item Name: Patient Stop

Start Date: 1/20/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

=> 10/05/31

1

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

Memo

START TIME: 10:00AM FINISH TIME: 10:30pm OVEN TEMPERATURE: 320°F

=> 10/05/31

1

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

1 BR 10-5-31.

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Item ID: D2492

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

190



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location:

Memo

Set Up/
Run Hours

0.00

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200



QC

Quality Control

QC21 - Final Inspection - Work Order Release

Memo

0.00

0.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



P114801 ①

10/06/02

C2101611

Picklist Print

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Page 1

Work Order ID: 55551



Parent Item: D2492



Parent Item Name: Patient Stop

Start Date: 1/20/10

Required Date: 1/29/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP E 00.06.26 Removed P/O for powder coat EC
 IPP Rev:F Now 6061-T6 06-06-23 JLM
 IPP Rev:G now water jet 07-12-11 DD

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last
M6061T6S.080		Purchased	No		



6061-T6 .080 Sheet

Route	Unit of	Qty on	Remaining	Qty	Date	Status
100	sf	178.9597	19.1884			



B10-1-21

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

178.95967

110630

35.0136

112141

0.86727

112763

6.85

113438

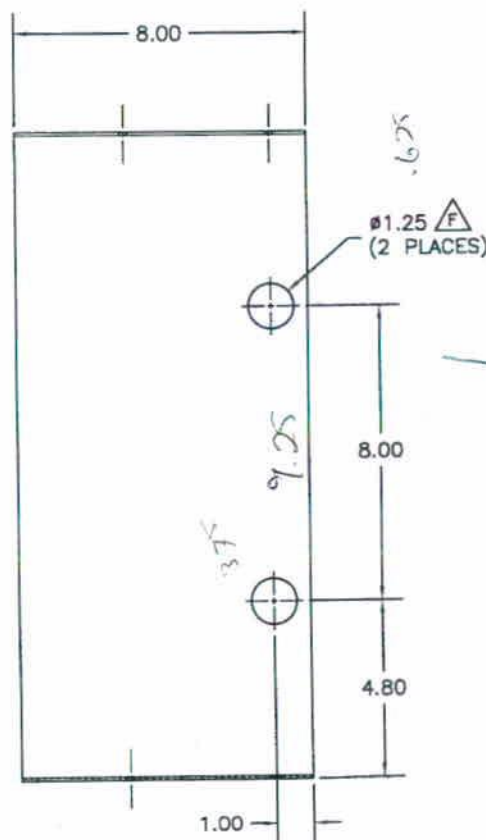
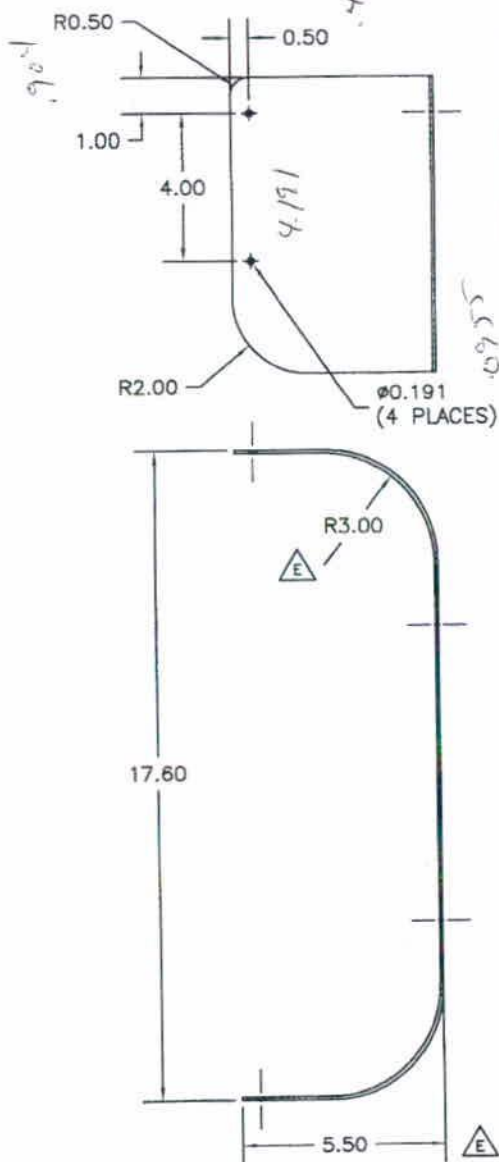
136.2288

113438

(15)

DART

DESIGN KE	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D2492	REV. F SHEET 1 OF 1
DATE 06.09.14	TITLE PATIENT STOP		SCALE 1:5
A	95.10.24	NEW ISSUE	
B	96.02.28	MINOR CHANGES	
C	97.07.14	CHANGED MATERIAL AND FINISH	
D	98.05.11	R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION	
E	06.05.30	ADD 6061-T6 MATERIAL, R3.0 WAS R4.00, 5.50 WAS 6.00	
F	06.09.14	Ø1.25 WAS Ø1.020	

**D2492 PATIENT STOP**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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